

## ABSTRACT

A material member blanked from metal sheet is subjected to upsetting to form an annular peripheral portion that is thinner than the center part of the material inside the annular portion, and the thicker inside portion is formed into a concavity. The first intermediate product thus formed is drawn to form a cup-shaped case with an internal boss and/or an external boss, and an outside flange. The intermediate product can also be used to make gears and the like.